

Work Order ID 148100

Friday, June 24, 2016 10:48:49 AM

148100

Page 1

Item ID: D2573

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Aft, Out

Start Date: 6/16/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/28/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2573	F
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100

0.02

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program Batch No. 148100Double check by: SM

0.48

DAS
08
9-89

b. 16/07/07

8

0

DAS
44
9-89

16-06-29

DAS
14
9-89

16/06/30

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

110

0.00

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Machine keyway as per dwg D2573 & D2574

0.12

DAS
08
9-89

b. 16/07/07

8

0

DAS
44
9-89

16-07-05

DAS
14
9-89

16/07/06

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Item ID: D2573

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Aft, Out

Start Date: 6/16/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/28/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.01				8	0		DAS 14 08/09 16/06/30 DAS 44 9-89 16-07-05
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.03				8			16-7-7
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.05				8			DAS 34 9-89 20/6/07/11 3 E13

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Saddle, Aft, Out

Start Date: 6/16/2016 **Start Qty:** 8.00 ***g***

Cust Item ID:

Required Date: 6/28/2016 **Req'd Qty:** 8.00 ***Q***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum 0.00

150

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9.00

0.03

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.01

Quality Control

170

Identify as per dwg & Stock Location: E398 0.00

0.00

170

Packaging

Memo

0.01

Packaging

Work Order ID 148100

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Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Aft, Out
Start Date: 6/16/2016 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 6/28/2016 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.13							
Quality Control									

DAS
21
9-89 JUL 13 2016

Picklist Print

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Page 1

Work Order ID: 148100

148100

Parent Item: D2573

D2573

Parent Item Name: Saddle, Aft, Out

Start Date: 6/16/2016

Required Date: 6/28/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	28.0000	1	8			
D6101-007									**				
Saddle Billet													

DAS
44
9-89 16-06-28

Location

Loc Qty

Loc Code

MAT041

28

143818

6

144497

2

146279

20

5
2
1

DART AEROSPACE LTD		Work Order: 148100
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.260	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.501	.501	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.569	.569	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.135	.135	.135	.135		
Q	0.115	0.135		.126	.129	.130	.129		
R	0.240	0.260		.248	.252	.253	.253		
S	0.115	0.135		.130	.127	.125	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.227	3.227	3.226		
V	0.230	0.250		.240	.238	.236	.238		
W	0.115	0.135		.130	.130	.130	.130		
X	0.308	0.313		.313	.313	.313	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.364	.363	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.060	.060	.063	.063		
AD	0.240	0.260		.247	.248	.246	.248		
AE	1.500	1.520		1.510	1.514	1.514	1.512		
AF	0.115	0.135		.132	.125	.125	.126		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.245	.245	.245	.246		
AI	2.000	2.020		2.0005	2.0045	2.005	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: <i>DM</i>	DAS 44
Date: 16/06/36	16/07/05

Audited by: <i>SL</i>
Date: 16-7-7

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 148100
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.500	0.500	0.500	0.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.501	0.501	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	0.569	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.135	.125	0.135	0.135		
Q	0.115	0.135		.129	.129	.129	.129		
R	0.240	0.260		.251	.252	0.252	0.252		
S	0.115	0.135		.127	.128	0.127	0.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.227	3.227	3.227	3.227		
V	0.230	0.250		.236	.236	0.240	0.241		
W	0.115	0.135		.130	.129	0.125	0.124		
X	0.308	0.313		0.312	0.312	0.312	0.312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.362	0.362	0.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		0.625	0.625	0.625	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		.248	.247	0.250	0.252		
AE	1.500	1.520		1.512	1.512	1.512	1.510		
AF	0.115	0.135		.125	.125	0.125	0.125		
AG	0.240	0.280		.275	.275	0.275	0.275		
AH	0.240	0.260		.247	.247	0.249	0.249		
AI	2.000	2.020		2.002	2.0015	2.0016	2.000		
AJ	0.023	0.043	.033	2.002					
Accept/Reject									

Measured by: 14	DAS
Date: 16/07/06	08

Audited by: 11
Date: 16-7-7

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

